

Please cut ASAP

Work Order ID 139043

139043

Page 1

Friday, November 13, 2015 11:21:38 AM

Item ID: D3561-1 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Seal Insert Tool

Start Date: 11/13/2015 Start Qty: 4.00 *4*

Required Date: 11/13/2015 Req'd Qty: 4.00 *4*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLJ Date: NOV 17 2015 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3561	Rev A

100

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3561 Dwg Rev: A Prog Rev: A 2-

Deburr if necessary

0.00

0.00

(4) _____ 11/15/12/21

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

(4) _____ 11/15/12/21

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

(4) 11-12-22. _____ DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Friday, November 13, 2015 11:21:37 AM

Page 1

Work Order ID: 139043

139043

Parent Item: D3561-1

D3561-1

Parent Item Name: Seal Insert Tool

Start Date: 11/13/2015

Required Date: 11/13/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A06.10.19New issueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased			No	100	sf	122.2750	0.0473	0.199158			

M304S11GA

304/316 0.125 Sheet

DU 15/12/21

Location

Loc Qty

Loc Code

MAT020

122.27498

M128254

35.775

M129545

30.24998

M129972

56.25

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

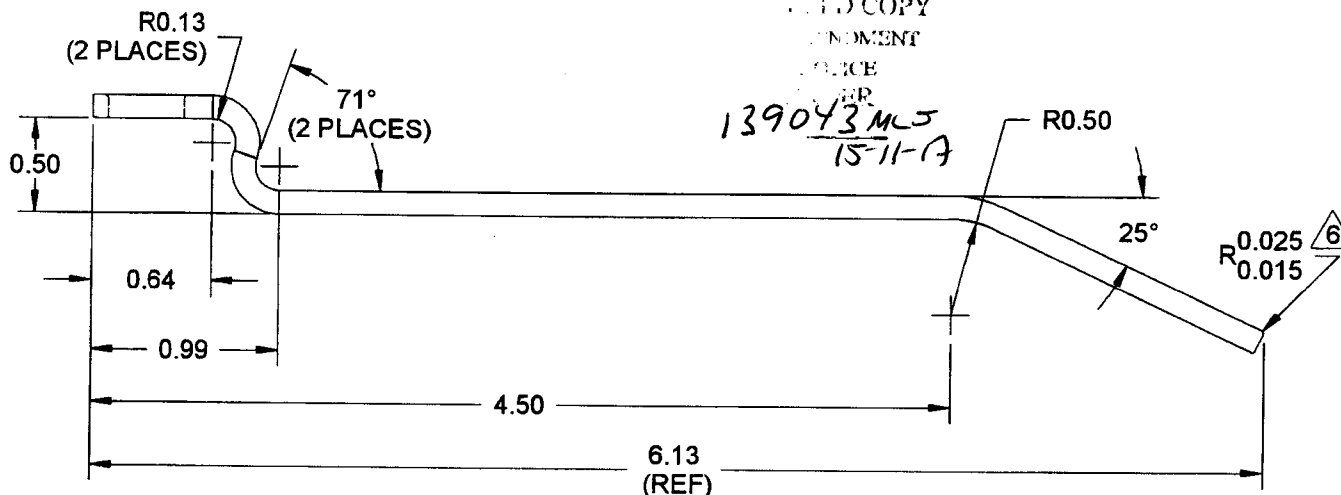
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DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. A
DRAWING NO. D3561
SHEET 1 OF 1
SCALE 1:1
TITLE SEAL INSERT TOOL
NEW ISSUE

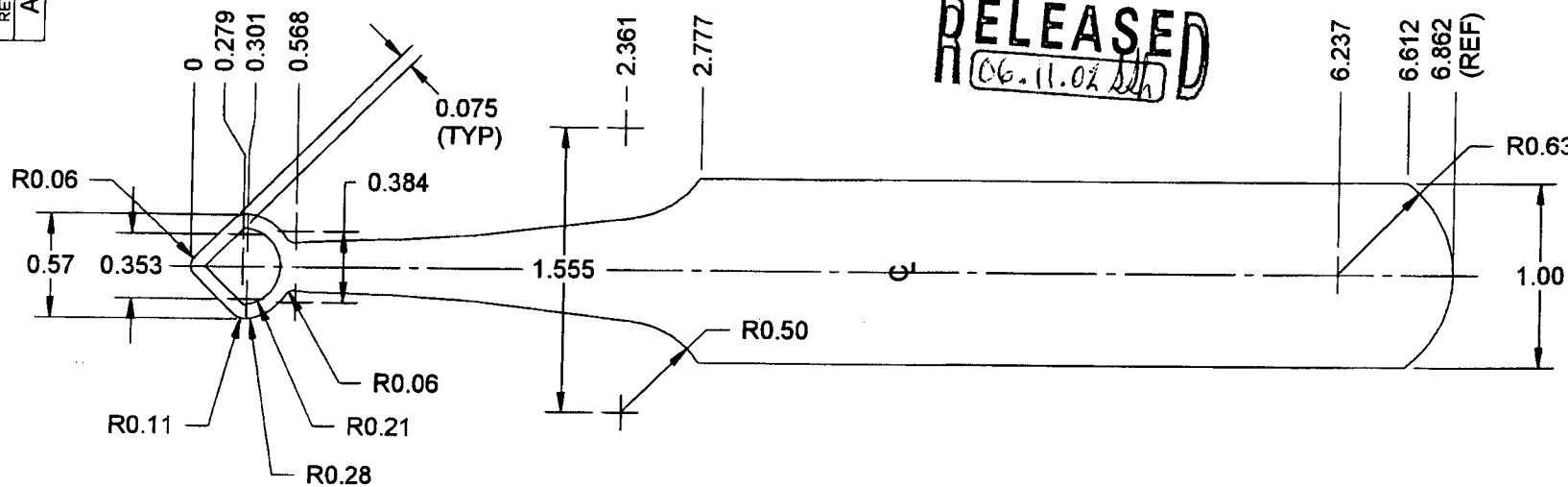
DESIGN BY [Signature]
CHECKED BY [Signature]
DATE 06.10.06
APPROVED BY [Signature]
DATE 06.10.06
REV. A



D3561-1 SEAL INSERT TOOL

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK, PER MIL-S-5059 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S10GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP CORNERS 0.015 TO 0.025



D3561-1F SEAL INSERT TOOL FLAT PATTERN

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